

Work Order ID 63763

Friday, November 12, 2010 11:58:43 AM



LT

Page 1

Item ID: D4278-045

Accept



Setup Start

Revision ID: PRELIM

Item Name: Rib Assembly, Fwd Cham



Stop



Start Date: 11/15/2010 Start Qty: 2.00



Required Date: 11/16/2010 Req'd Qty: 2.00



Cust Item ID:

Customer:

PRELIMINARY ISSUE

Reference:

Run Start



Stop



Approvals: Process Plan: mf

Date: 10-11-12

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4278

PA1

100

Weld per dwg A/R S.S. rod Batch: 11585

0.00

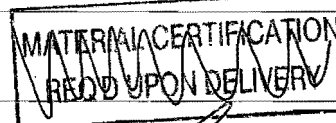
Large Fab

Memo

0.00

Large Fab

1- Assemble ribs and weld as per dwg DT



PL 10-11-16 (2x)

110

QC9- Inspect visual per QS1004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

PL 10-11-16 2

120

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

2x 10-11-17
PA1

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Page 2

Item ID:	D4278-045	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Rib Assembly, Fwd Cham					
Start Date:	11/15/2010	Start Qty:	2.00		Cust Item ID:	
Required Date:	11/16/2010	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Identify as per dwg & Stock Location: <i>B/C</i>	0.00				<i>(2)</i>	<i>10.11.17</i>		
Packaging	Memo	0.00							
Packaging	***STOCK IN BASKET CELL***								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10. Test Repeat RWA
10.11.22
10-11-17
(2)

POSITIVE RECALL
EFFECTIVE _____ AUTH _____
RELEASED _____ DATE _____

Picklist Print

Page 1

Friday, November 12, 2010 11:58:43 AM

Work Order ID: 63763



Parent Item: D4278-045



Parent Item Name: Rib Assembly, Fwd Cham





Start Date: 11/15/2010

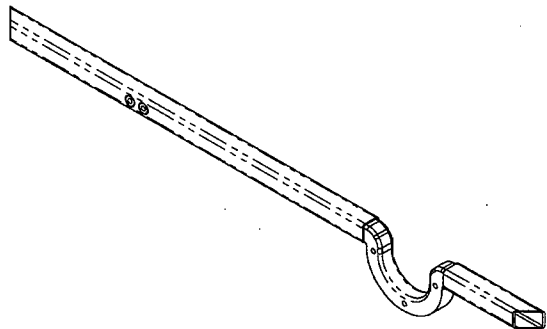
Required Date: 11/16/2010

Start Qty: 2.00

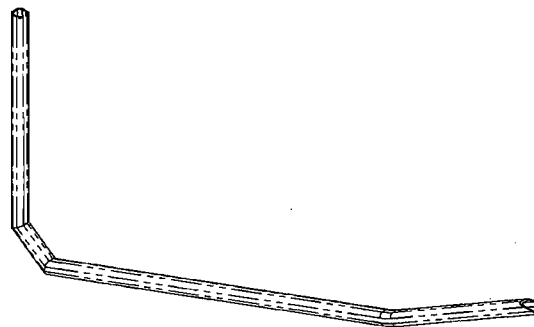
Required Qty: 2.00

Comments: IPP Rev:A 10.11.12 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4277-11  Rib		Manufactured	No			100	Each	0.0000	1	2			
D4277-7  Rib		Manufactured	No			100	Each	0.0000	1	2			
										 B63777 → (2)			
										 B63776 → (2)			

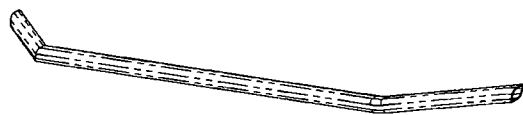


D4278-041 UPPER RIB ASSY-HOOP

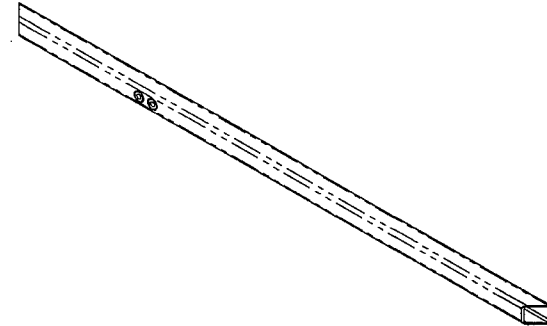


D4278-043 RIB ASSY, AFT CHAM

63763



D4278-045 RIB ASSY, FWD CHAM

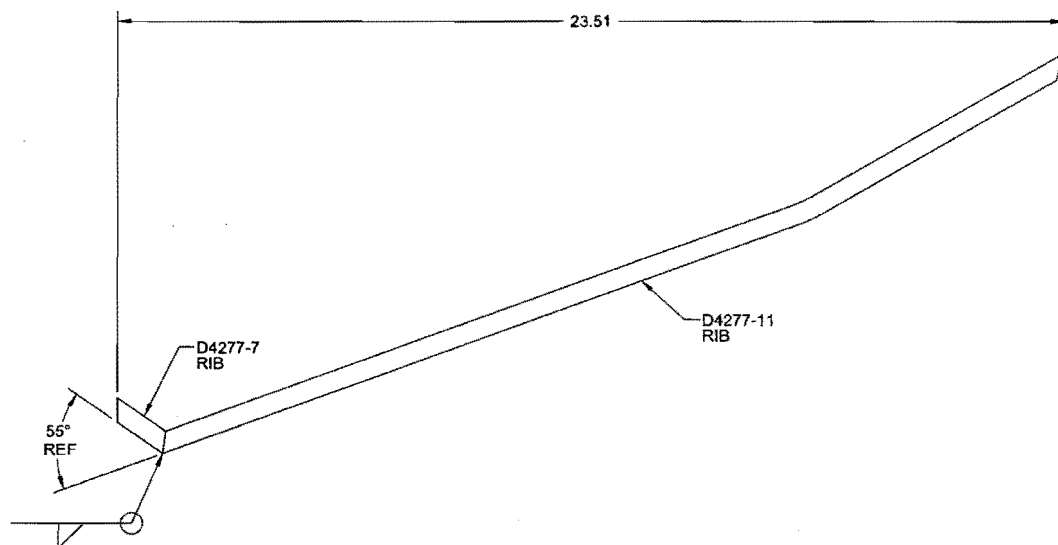


D4278-047 UPPER RIB ASSY-STRAIGHT

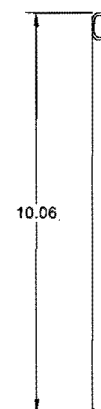
PRELIMINARY ISSUE
Nov. 11, 2010

PA1	PRELIMINARY	JPH	10.11.11
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO.	REV. PA1
MFG. APPR.	JPH	D4278	SHEET 1 OF 5
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	RIB ASSEMBLY	NTS
DATE	10.11.11	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY	PART NUMBER	DESCRIPTION
	1	D4278-045	RIB ASSY, FWD CHAM
1	1	D4277-7	MID CORNER RIB, NOTCH
2	1	D4277-11	MID DIAG RIB



#6 3763



D4278-045 RIB ASSY, FWD CHAM

NOTES:

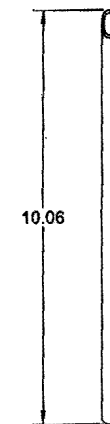
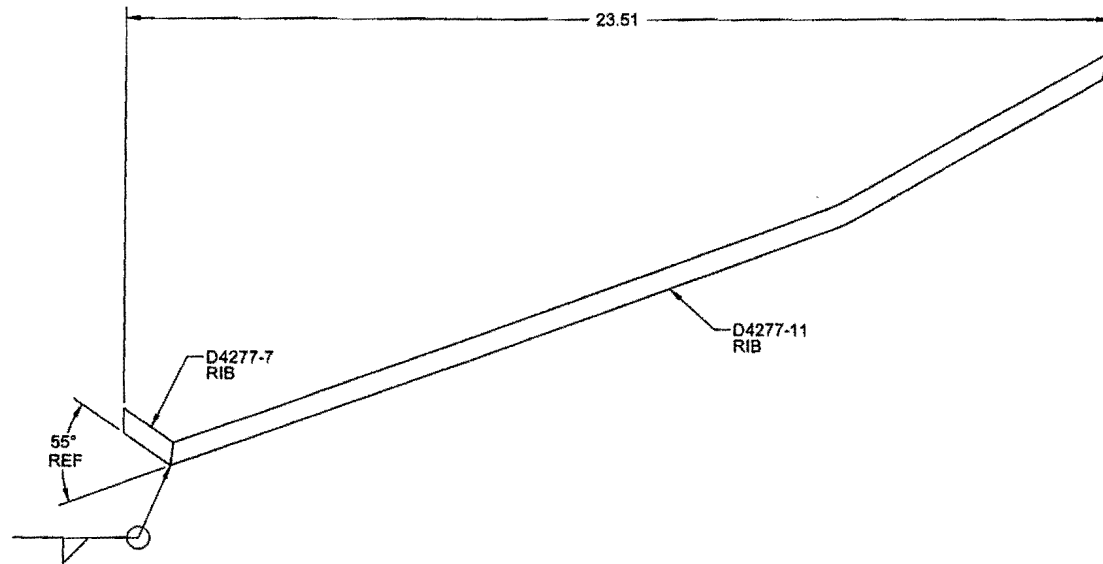
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.57 lbs
- 8) WELD PER DART QSI 004.

PRELIMINARY ISSUE

Nov 11, 2010

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4278	REV. PA1
MFG. APPR.	<i>[Signature]</i>	SHEET 4 OF 5	
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DATE	10.11.11		

		D4278-045	RIB ASSY, FWD CHAM
1	1	D4277-7	MID CORNER RIB, NOTCH
2	1	D4277-11	MID DIAG RIB



D4278-045 RIB ASSY, FWD CHAM

- NOTES:**
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